

Work Order ID 67663

Tuesday, March 29, 2011 9:23:28 AM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MMF Date: 11-03-29 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2572	Rev E

100

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. 67663
Double check by: MMF
1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and insp

J.F.S.
B.A 11/05/04

12 0

110

0.00



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2571 & D2572

J.F.S.
B.A 11/05/04

12 0

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Tuesday, March 29, 2011 9:23:28 AM



Page 2

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

J.F.S.
B.A 11/05/04

12

φ

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 11/05/05

(12)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12

φ

HL

11/05/05

Work Order ID 67663

Tuesday, March 29, 2011 9:23:28 AM



Page 3

Item ID: D2572	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Saddle, Fwd In 205				
Start Date: 3/30/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 4/13/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating N116964	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 10:15 OVEN TEMPERATURE: 320 FINISH TIME: 10:45	0.00 0.00							(2x) M-L 11/05/07
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							SAD 11-05-07 (12)
170 Packaging Packaging	Identify as per dwg & Stock Location: 433 Memo	0.00 0.00							11/05/07 (12)

Work Order ID 67663

Tuesday, March 29, 2011 9:23:28 AM



Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/s k [Signature]

MF
11-05-09

Picklist Print

Tuesday, March 29, 2011 9:23:25 AM

Page 1

Work Order ID: 67663



Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 3/30/2011

Required Date: 4/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 		Manufactured	No			100	Each	87.0000	1	12			

Saddle Billet

Location

Loc Qty

Loc Code

MAT045

30

66966

30

MAT046

57

65382

17

65953

20

66966

20

1/66966
1/65382

J.F.S.

DART AEROSPACE LTD	Work Order: 67663
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.441"	0.442"	0.442"	0.442"	vern.	J-F-05
B	1.745	1.755		1.751"	1.749"	1.751"	1.751"	"	
C	3.495	3.505		3.501"	3.500"	3.500"	3.497"	"	
D	1.745	1.755		1.748"	1.749"	1.749"	1.752"	"	
E	7.990	8.010		7.997"	7.999"	7.999"	8.000"	vern.	CNC-02
F	0.490	0.510		0.498"	0.500"	0.500"	0.500"	vern.	J-F-05
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"	"	
H	0.375	0.380		0.376"	0.376"	0.376"	0.376"	"	
I	0.490	0.510		0.500"	0.500"	0.502"	0.500"	"	
J	1.174	1.184		1.179"	1.180"	1.180"	1.180"	"	
K	0.558	0.578		0.569"	0.569"	0.569"	0.569"	"	
L	1.174	1.184		1.179"	1.181"	1.181"	1.181"	"	
M	1.490	1.500		1.496"	1.496"	1.496"	1.496"	"	
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"	"	
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"	"	
P	0.115	0.135		0.124"	0.123"	0.123"	0.123"	Mic	J-F-04
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"	vern.	J-F-05
R	0.240	0.260		0.252"	0.253"	0.252"	0.252"	Mic	J-F-04
S	0.115	0.135		0.129"	0.131"	0.128"	0.130"	Mic	118-120
T	0.178	0.198		R0.188	R0.188	R0.188	R0.188	R.G.	Ref.
U	2.940	2.980		2.960"	2.961"	2.961"	2.961"	vern.	J-F-05
V	0.230	0.250		0.231"	0.234"	0.231"	0.233"	vern.	J-F-05
W	0.115	0.135		0.135"	0.127"	0.126"	0.125"	Mic	118-120
X	0.307	0.312		0.312"	0.311"	0.311"	0.311"	Mic	J-F-04
Y	0.760	0.765		0.762"	0.762"	0.762"	0.762"	vern.	J-F-05
Z	0.352	0.372		0.361"	0.363"	0.360"	0.365"	Mic	118-120
AA	0.470	0.530		R0.500	R0.500	R0.500	R0.500	R.G.	Ref.
AB	0.615	0.635		0.626"	0.628"	0.628"	0.628"	vern.	J-F-05
AC	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R.G.	Ref.
AD	0.240	0.260		0.248"	0.251"	0.245"	0.243"	Mic	118-120
AE	1.375	1.395		1.389"	1.386"	1.389"	1.390"	Dial	HAAS#2
AF	0.115	0.135		0.135"	0.135"	0.135"	0.135"	vern.	J-F-05
AG	0.240	0.280		0.280"	0.280"	0.280"	0.280"	"	
AH	0.240	0.260		0.248"	0.252"	0.249"	0.249"	Mic	118-120
AI	2.000	2.020		2.005"	2.002"	2.005"	2.006"	Dial	HAAS#2
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"	vern.	J-F-05
Accept/Reject									

Measured by: J.F.S.
Date: 11/05/03

Audited by: SL
Date: 11/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 67663
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	76	77	78	By	Date
A	0.438	0.443		0.442"	0.442"	0.442"	0.442"	vern.	J.F.-05
B	1.745	1.755		1.749"	1.750"	1.751"	1.750"	"	
C	3.495	3.505		3.500"	3.502"	3.501"	3.500"	"	
D	1.745	1.755		1.750"	1.747"	1.750"	1.750"	"	
E	7.990	8.010		8.000"	7.999"	8.000"	7.999"	vern.	CNL-02
F	0.490	0.510		0.500"	0.503"	0.505"	0.503"	vern.	J.F.-05
G	0.257	0.262		0.258"	0.258"	0.258"	0.258"	"	
H	0.375	0.380		0.376"	0.376"	0.376"	0.376"	"	
I	0.490	0.510		0.501"	0.501"	0.502"	0.502"	"	
J	1.174	1.184		1.181"	1.181"	1.181"	1.181"	"	
K	0.558	0.578		0.569"	0.569"	0.569"	0.569"	"	
L	1.174	1.184		1.179"	1.179"	1.179"	1.179"	"	
M	1.490	1.500		1.496"	1.496"	1.496"	1.496"	"	
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"	"	
O	3.869	3.879		3.874"	3.874"	3.874"	3.874"	"	
P	0.115	0.135		0.125"	0.124"	0.124"	0.124"	Mic	J.F.-04
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"	vern.	J.F.-05
R	0.240	0.260		0.252"	0.251"	0.252"	0.251"	Mic	J.F.-04
S	0.115	0.135		0.127"	0.125"	0.126"	0.126"	Mic	118-120
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"	R.G.	Ref.
U	2.940	2.980		2.961"	2.961"	2.961"	2.961"	vern.	J.F.-05
V	0.230	0.250		0.232"	0.232"	0.235"	0.234"	"	
W	0.115	0.135		0.130"	0.130"	0.133"	0.132"	Mic	118-120
X	0.307	0.312		0.310"	0.310"	0.310"	0.310"	Mic	J.F.-04
Y	0.760	0.765		0.762"	0.762"	0.762"	0.763"	vern.	J.F.-05
Z	0.352	0.372		0.365"	0.365"	0.366"	0.365"	Mic	118-120
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"	R.G.	Ref.
AB	0.615	0.635		0.628"	0.627"	0.628"	0.623"	vern.	J.F.-05
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"	R.G.	Ref.
AD	0.240	0.260		0.245"	0.245"	0.244"	0.242"	Mic	118-120
AE	1.375	1.395		1.391"	1.391"	1.391"	1.391"	Dial	HAAS#2
AF	0.115	0.135		0.135"	0.135"	0.135"	0.135"	vern.	J.F.-05
AG	0.240	0.280		0.280"	0.280"	0.280"	0.280"	"	
AH	0.240	0.260		0.246"	0.246"	0.245"	0.246"	Mic	118-120
AI	2.000	2.020		2.007"	2.007"	2.007"	2.007"	Dial	HAAS#2
AJ	0.023	0.043		0.033"	0.033"	0.033"	0.033"	vern.	J.F.-05
Accept/Reject									

Measured by:	J.F.S.
Date:	11/05/03

Audited by:	JL
Date:	11/05/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	67665
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

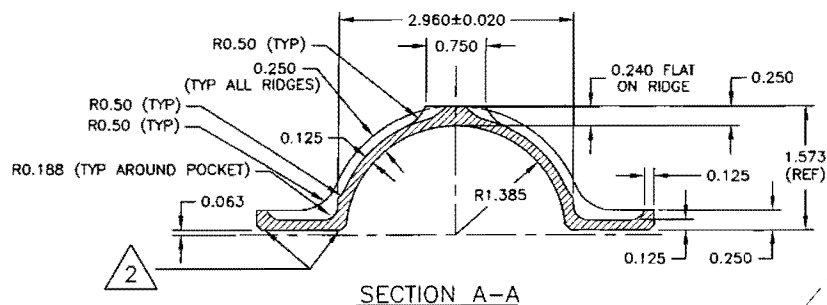
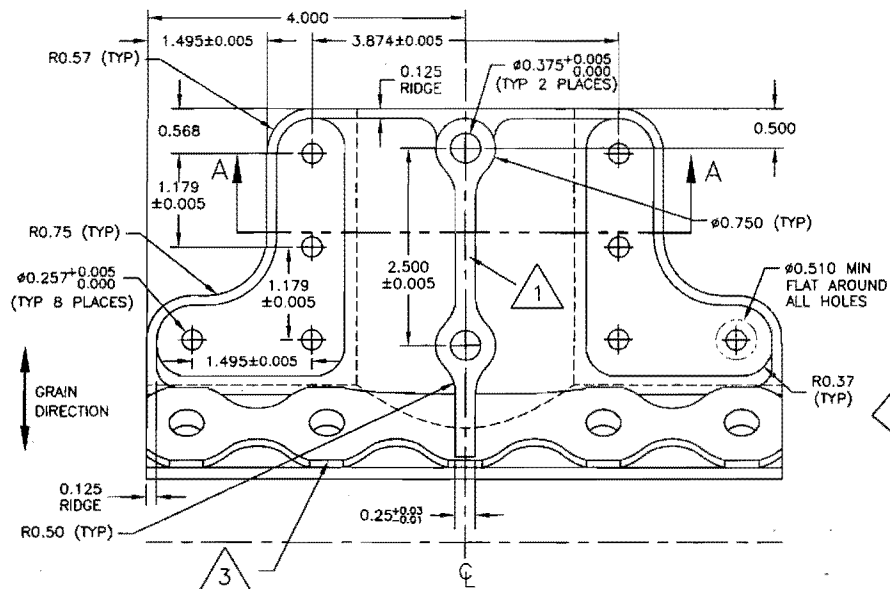
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	211	212	By	Date
A	0.438	0.443		0.443	0.443	0.443	0.443	Vern	GA-01
B	1.745	1.755		1.750	1.750	1.750	1.750	"	"
C	3.495	3.505		3.500	3.500	3.500	3.500	"	"
D	1.745	1.755		1.750	1.750	1.750	1.750	"	"
E	7.990	8.010		8.000	8.000	8.000	8.000	Vern	CNC-02
F	0.490	0.510		0.500	0.499	0.499	0.500	Vern	GA-01
G	0.257	0.262		0.258	0.258	0.259	0.259	"	"
H	0.375	0.380		0.376	0.376	0.377	0.377	"	"
I	0.490	0.510		0.500	0.501	0.499	0.499	"	"
J	1.174	1.184		1.179	1.179	1.179	1.179	"	"
K	0.558	0.578		0.568	0.570	0.570	0.570	"	"
L	1.174	1.184		1.179	1.179	1.179	1.179	"	"
M	1.490	1.500		1.495	1.495	1.495	1.495	"	"
N	2.495	2.505		2.501	2.501	2.500	2.500	"	"
O	3.869	3.879		3.875	3.875	3.874	3.874	"	"
P	0.115	0.135		0.124	0.124	0.125	0.124	Mic	GA-03
Q	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
R	0.240	0.260		0.251	0.251	0.251	0.251	"	"
S	0.115	0.135		0.127	0.126	0.127	0.127	Mic	118-120
T	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
U	2.940	2.980		2.961	2.961	2.961	2.961	Vern	GA-01
V	0.230	0.250		0.235	0.234	0.234	0.234	"	"
W	0.115	0.135		0.125	0.125	0.124	0.126	Mic	118-120
X	0.307	0.312		0.310	0.310	0.310	0.310	Vern	GA-01
Y	0.760	0.765		0.763	0.763	0.763	0.763	"	"
Z	0.352	0.372		0.361	0.363	0.362	0.362	"	"
AA	0.470	0.530		0.500	0.500	0.500	0.500	R-6	ref.
AB	0.615	0.635		0.624	0.624	0.624	0.624	Vern	GA-01
AC	0.053	0.073		0.063	0.063	0.063	0.063	R-6	ref.
AD	0.240	0.260		0.240	0.241	0.241	0.241	Vern	GA-01
AE	1.375	1.395		1.340	1.390	1.390	1.390	Dial	HAAS2
AF	0.115	0.135		0.135	0.135	0.135	0.135	Vern	GA-01
AG	0.240	0.280		0.275	0.275	0.275	0.275	"	"
AH	0.240	0.260		0.246	0.245	0.246	0.246	"	"
AI	2.000	2.020		2.006	2.004	2.004	2.004	Dial	HAAS2
AJ	0.023	0.043		0.033	0.033	0.033	0.033	Vern	GA-01
Accept/Reject									

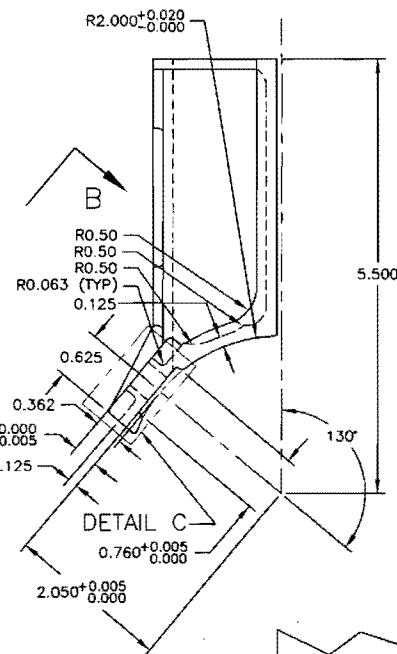
Measured by:	J.F.S. / B.A.
Date:	11/05/04

Audited by:	SL
Date:	11/05/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DETAIL C
SCALE 2:1

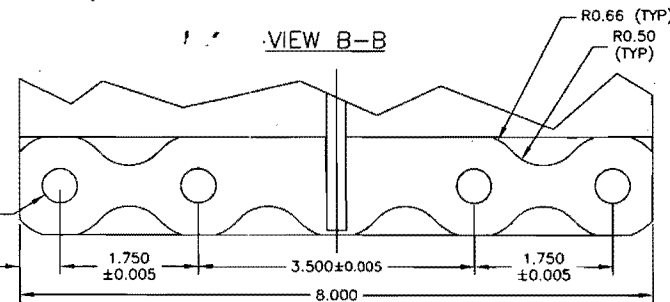


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. E
DATE	05.07.13	TITLE	INNER FWD SADDLE	D2572	SHEET 1 OF 1
		SCALE	2:3		